

Work Order ID 102078***102078***

Page 1

Thursday, May 23, 2013 1:40:59 PM

Item ID: D2370-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Litter Assembly

Start Date: 5/23/2013 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/6/2013 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: AMEDate: 5-23 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2370

D

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue p/o: 19229

Order: Model 12-2A undrilled with grey pad & black belts

Supplier: Ferno Aviation

Letter of compliance required

C2 13/05/23 (4)

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Insure that letter of compliance is attached to w/o

13/1/23 (4)

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

13-7-234

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Page 2

Item ID: D2370-041

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Litter Assembly

Stop ***NS2***

Start Date: 5/23/2013 Start Qty: 4.00

4

Cust Item ID:

Required Date: 6/6/2013 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Small Fab	0.00							
130									
Small Fab	Memo	0.00							
Small Fab	1- Assemble as per Dwg D2370								
	2- Transfer drill using D4812-041 as template and open to size 0.257" as per Dwg D2370								
	3- Ensure fit of D4812-041 and remove for shipping ***D4812-041 MUST STAY WITH LITTER FRAME***								
	4- Deburr								
140	QC5- Inspect part completeness to step on W/O	0.00							
140									
QC	Memo	0.00							
Quality Control	Check for loose rivet and ensure fit of D4812-041								

N
A
mf
13-7-23
will assemble on w/o D2370-1 #104894.

DQA: _____ Date: _____



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Page 3

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Litter Assembly

Stop ***NS2***

Start Date: 5/23/2013 Start Qty: 4.00

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Required Date: 6/6/2013 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: GA.

0.00

150

Packaging

Memo

0.00

Packaging

MF 13-7-23

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

13/7/24 DJ

MF 13-7-23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Doc/Data									
Equip/Tooling									
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Picklist Print

Thursday, May 23, 2013 1:40:58 PM

Page 1

Work Order ID: 102078
Parent Item: D2370-041
Parent Item Name: Litter Assembly

Start Date: 5/23/2013 Required Date: 6/6/2013
Start Qty: 4.00 Required Qty: 4.00

Comments: IPP REV:A 13.05.21 AS PER DWG REV.D VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2370-IP Litter Frame Assembly		Manufactured	No				Each	0.0000		4		10-25-78	
D2374 Stud		Manufactured	No				Each	45.0000		16			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST009		45							
				95796		11							
				98114		34							
D2378 Bolt		Manufactured	No				Each	39.0000		16		13-7-23	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST009		39							
				79476		4							
				89339		10							
				97240		25							
D2379 Restraint Belts		Manufactured	No				Each	0.0000		8			
D2484 Lock Nut		Manufactured	No				Each	80.0000		16			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				Mezz		80							
				22016		80							
AN960JD416L Washer	NAS1149D0416J	Purchased	No				Each	6.0000		16			
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				FP001		6							
				110153		6							
D4812-041 Patient Stop Assembly		Manufactured	No				Each	0.0000		4			

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

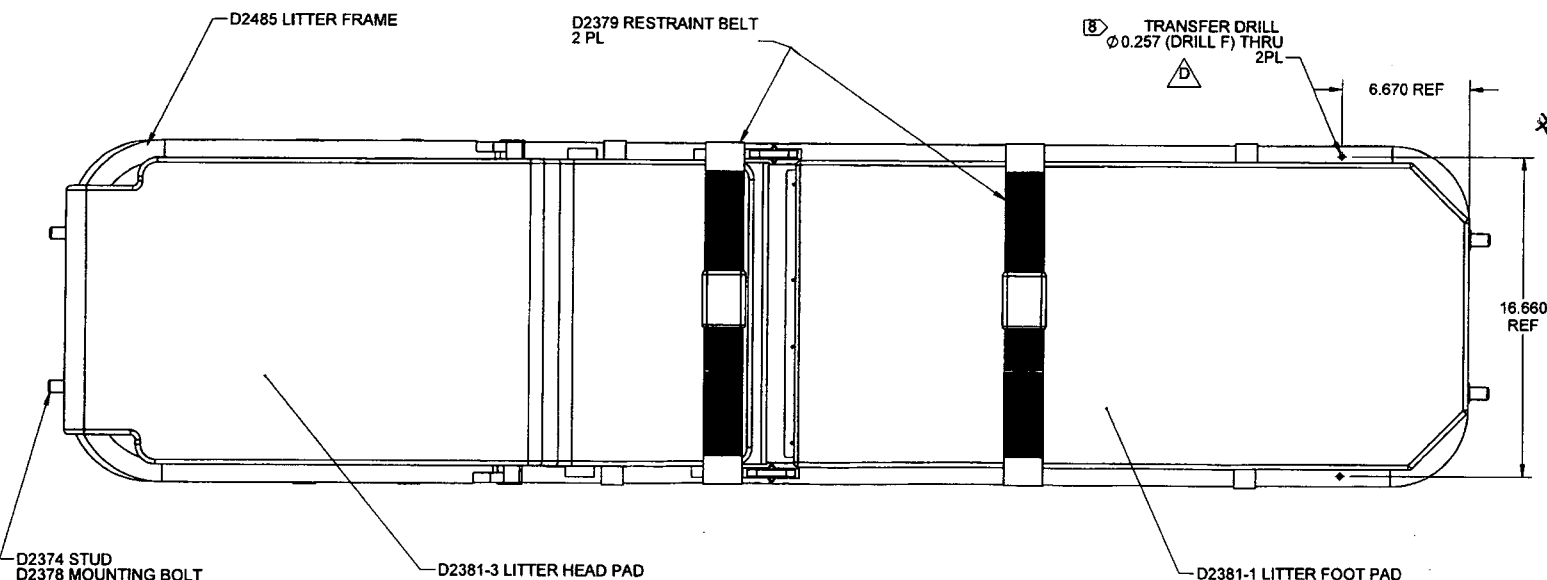
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 33%;"> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </td> <td style="width: 33%;"> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </td> <td style="width: 33%;"> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </td> <td style="width: 33%;"> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </td> </tr> </table>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
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FAULT CATEGORY

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ITEM	QTY -1	P/N	DESCRIPTION
	X	D2370-1	LITTER ASSEMBLY
1	4	D2374	STUD
2	4	D2378	MOUNTING BOLT
3	2	D2379	RESTRAINT BELT
4	1	D2381-1	LITTER FOOT PAD
5	1	D2381-3	LITTER HEAD PAD
6	4	D2484	LOCK NUT
7	1	D2485	LITTER FRAME
8	4	AN860JD416L	WASHER



D2370-1 LITTER ASSEMBLY

RELEASED
2013-05-16

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2370-1" USING A REMOVABLE TAG AS PER QSI 044 METHOD 6.6
- 7) WEIGHT: 24.69 Lbs
- 8) TRANSFER DRILL USING D4812-041 AS TEMPLATE. ENSURE FIT AND REMOVE FOR SHIPPING

DESIGN	DB	DART AEROSPACE LTD
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA
CHECKED	A.P.	DRAWING NO. D2370
MFG. APPR.	2/	REV. D
APPROVED	1/	SHEET 2 OF 2
DE APPR.	1/	SCALE
DATE	13.03.27	LITTER ASSEMBLY
		NTS

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Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO19229

Purchase Order Date 3/4/2013

PO Print Date 5/23/2013

Page Number 1 of 1

Order From :

FERNO AVIATION INC.
735-B BRANCH DR.
ALPHARETTA, GA 30004
US

VU-FER001

Contact Name

Vendor Phone 770 521 1005

Vendor Fax 770 521 0910

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr 10127-2607

Terms

Net 30

Currency

USD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED
CO 130513

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2370-1P	Litter Frame Assembl	5/31/2013 Yes	4.00 Each	Yellow Standard	\$1,491.0000	\$5,964.00
		Spec	AS PER DWG D2370 REV. D B102081 MODEL: 12-2A UNDRILLED WITH GREY PAD & BLACK BELTS				
2	D2370-1P	Litter Frame Assembl	5/31/2013 Yes	4.00 Each	Yellow Standard	\$1,491.0000	\$5,964.00
		Spec	AS PER DWG D2370 REV. D B102078 MODEL: 12-2A UNDRILLED WITH GREY PAD & BLACK BELTS				
PO Total:							\$11,928.00

Change Nbr: 3

Change Date: 5/23/2013

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required **YES** NO

FERNO Aviation, INC.

735-B Branch Drive
Alpharetta, GA 30004
Office 770.521.1005 Fax 770.521.0910
<http://aviation.ferno.com>

Packing Slip

DATE	PACKING SLIP NO.
7/15/2013	13275

BILL TO
Dart Aerospace, Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 Canada Attn: Chantel Lavoie

SHIP TO
Dart Aerospace, Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 Canada Ref: PO19229

P.O. NUMBER	TERMS	REP	SHIP DATE	SHIP VIA	FOB	
PO19229	Net 30	CW	7/15/2013	Yellow Freight	Alpharetta,GA	
ITEM	DESCRIPTION				QTY ORD.	QTY DEL.
12-2A (DART)	12-2A Litter Assembly W/Gray FAA Approved cover/pad assy. and Black FAA approved patient restraints (HS Code 8803.30.00.00) Litters include modifications requested by Dart., Serial # 13N261659, 13N261660, 13N261661,13N261662, 13N261663, 13N261664, 13N261665, 13N261666				8	8

Thank you for your order!

FERNO Aviation INC.

735B Branch Drive
Alpharetta, GA 30004

Telephone: 770.521.1005
Fax: 770.521.0910

CERTIFICATE OF CONFORMANCE

Date: 07/15/2013

Customer: Dart Aerospace, Inc.

P.O. Number: PO19229

<u>Part Number</u>	<u>Description</u>	<u>Serial Number</u>
Model 12-2A	Aeromedical Stretcher w/Orange FAA	13N261659
	Approved Cover and Black FAA Approved	13N261660
	Patient Restraints	13N261661
		13N261662
		13N261663
		13N261664
		13N261665
		13N261666

We hereby certify that all items in the above shipment have been produced, inspected and found to be in compliance with applicable drawings, customer specifications, and purchase order requirements including the flammability requirements of the Department of Transportation Federal Aviation Administration FAR 25.853 appendix F Part I(a)(1)(ii). All documents utilized were the latest revision in effect on the date of this order, or as specified by buyer.

Robert C. Chinn
QA, Ferno Aviation

Aircraft Belts Inc.
1176 Telecom Drive
Creedmoor NC 27522

Form: SC-108B
Phone: (800) 847-5651
Fax: (919) 956-4220



FAA R.S. #: YB1R632K

Packing Slip: 18462

Page: 1

PACKING SLIP / CERTIFICATION

TERMS: Net 30

Cust. ID: F38

Ship To:

Ferno Aviation
735-B Branch Drive
Alpharetta GA 30004

Sold To:

Ferno Aviation
735-B Branch Drive
Alpharetta GA 30004

PO: 7818
Ship Date: 3/22/2013

Ship Via: FedEx Ground
SO: 93651

FOB: ORIGIN
Sales Person: Duncan, Virginia

***** Ship UPS Ground acct # E1129E *****

Line	Planned Qty	Shipped Qty	Backorder	Part Number	Revision
1	50.00 EA	50.00	0.00	STFL	C

Description: STFC3030-810 Stretcher Belt -

3/26/13

DW

CERTIFICATION

This is to certify that the above components have been manufactured/repared and inspected in accordance with current Federal Aviation Regulations: TSO C-22 and/or TSO C-114 and found airworthy for service unless otherwise noted. The conditions and tests required for TSO approval of this article are minimum performance standards. It is the responsibility of those desiring to install either on or within a specific type of class of aircraft to determine that the aircraft installation conditions are within the TSO standards. If not within the TSO standards, the article may be installed only if further evaluation by the applicant documents an acceptable installation and is approved by the administrator. Details of this manufacture/repair are on file at this facility.

BY:

[Signature]